

material foaming with conventional method



first cooling step



air-circulating oven post-cure step



second cooling step

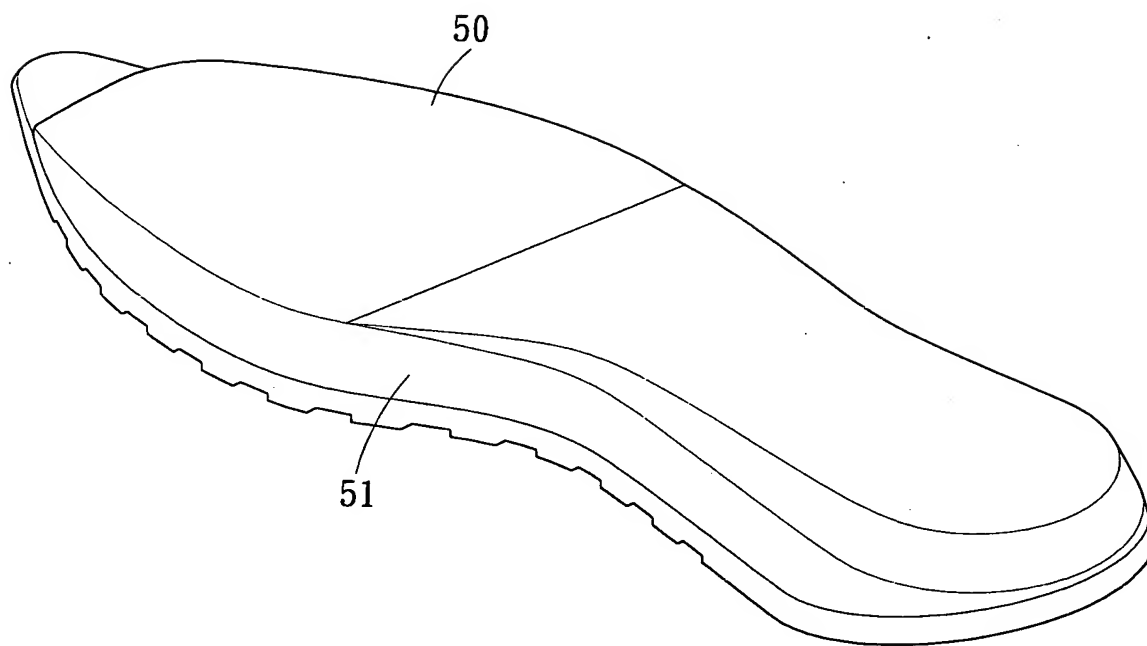


cutting foamed soles into desired shape
(wastes produced after cutting occupy about
20% of the raw materia)



semi-finished products

F I G. 1
PRIOR ART



F I G. 2
PRIOR ART

inputting pre-calculated foaming material
in mold



forming the material in mold



cooling action



semi-finished product

F I G. 3

compressing portions "a" and "b" with
middle plate



cleaning off the scraps of the raw material
after compression



inputting foaming material in mold



in mold foaming in a vacuum platform for
5 minutes at centigrade 150 deg



cooling the sole



semi-finished products

F I G. 4

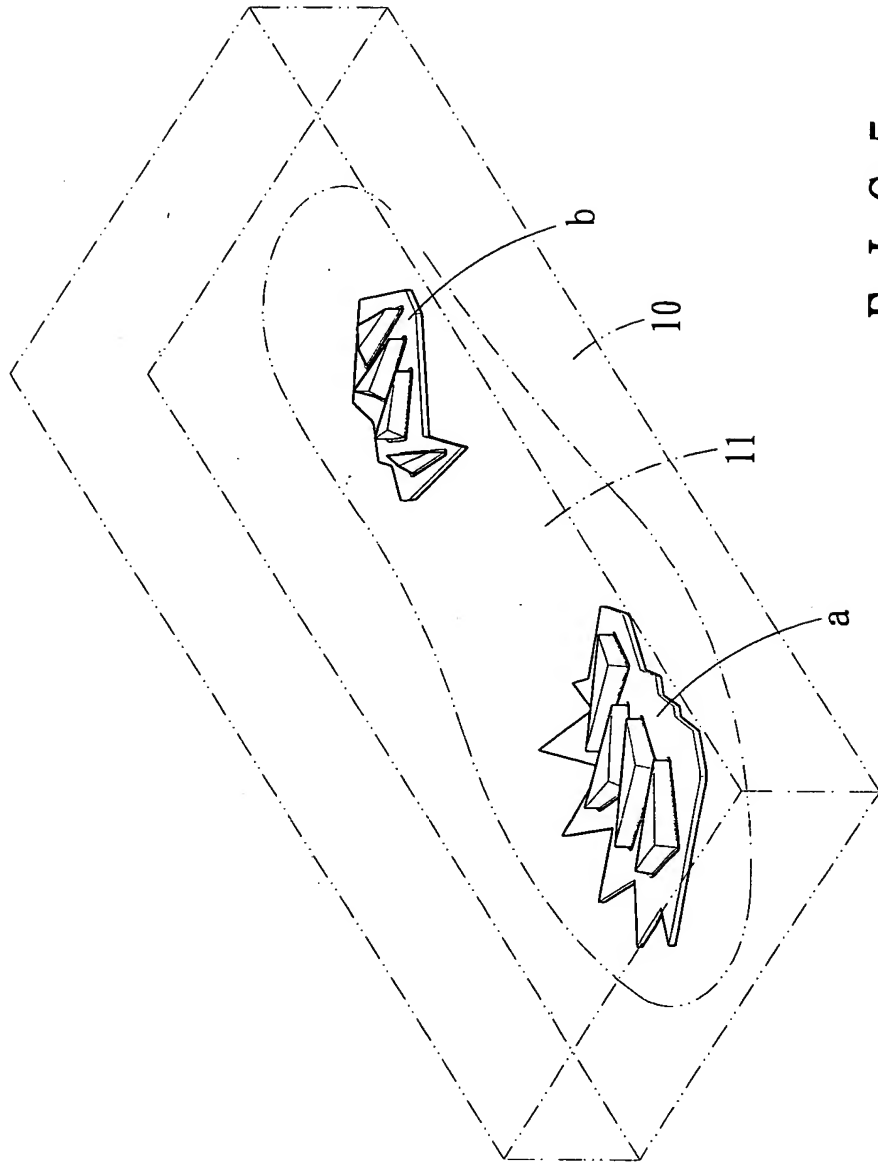


FIG. 5

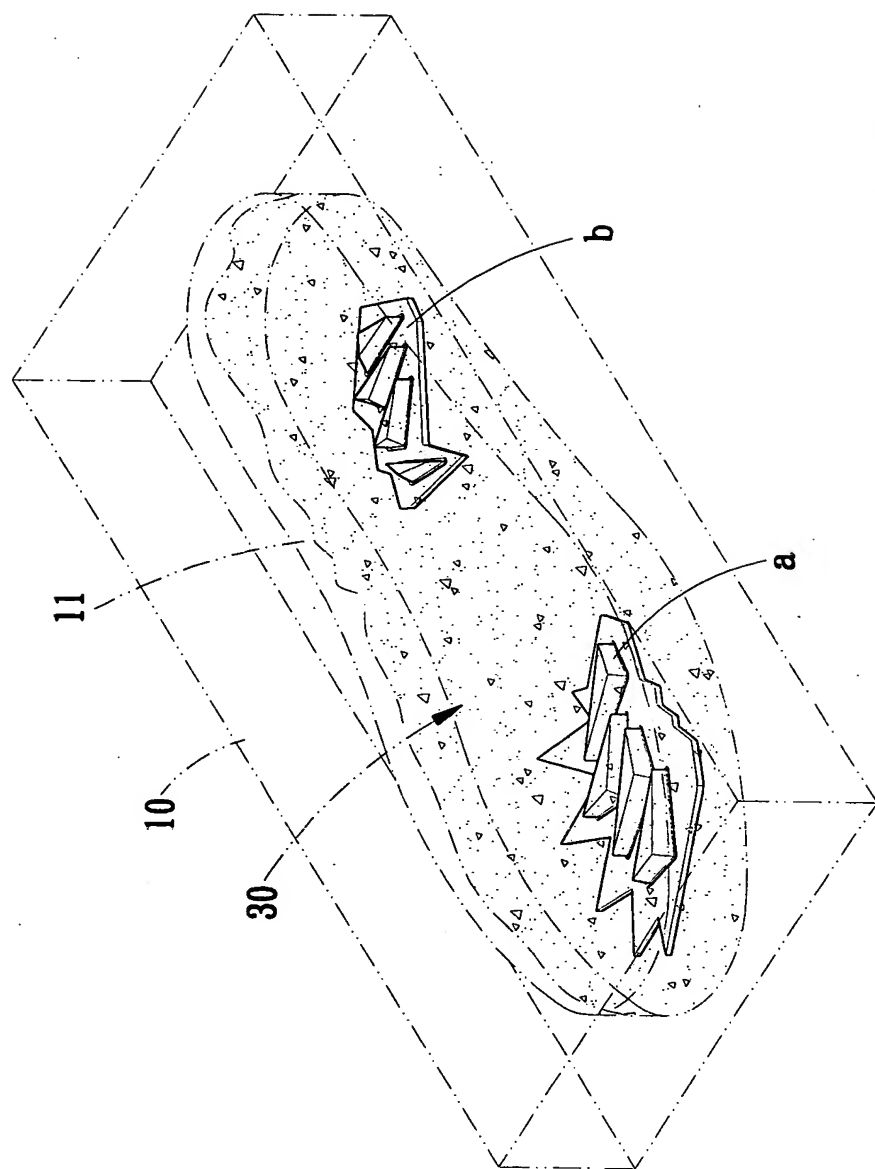


FIG. 6

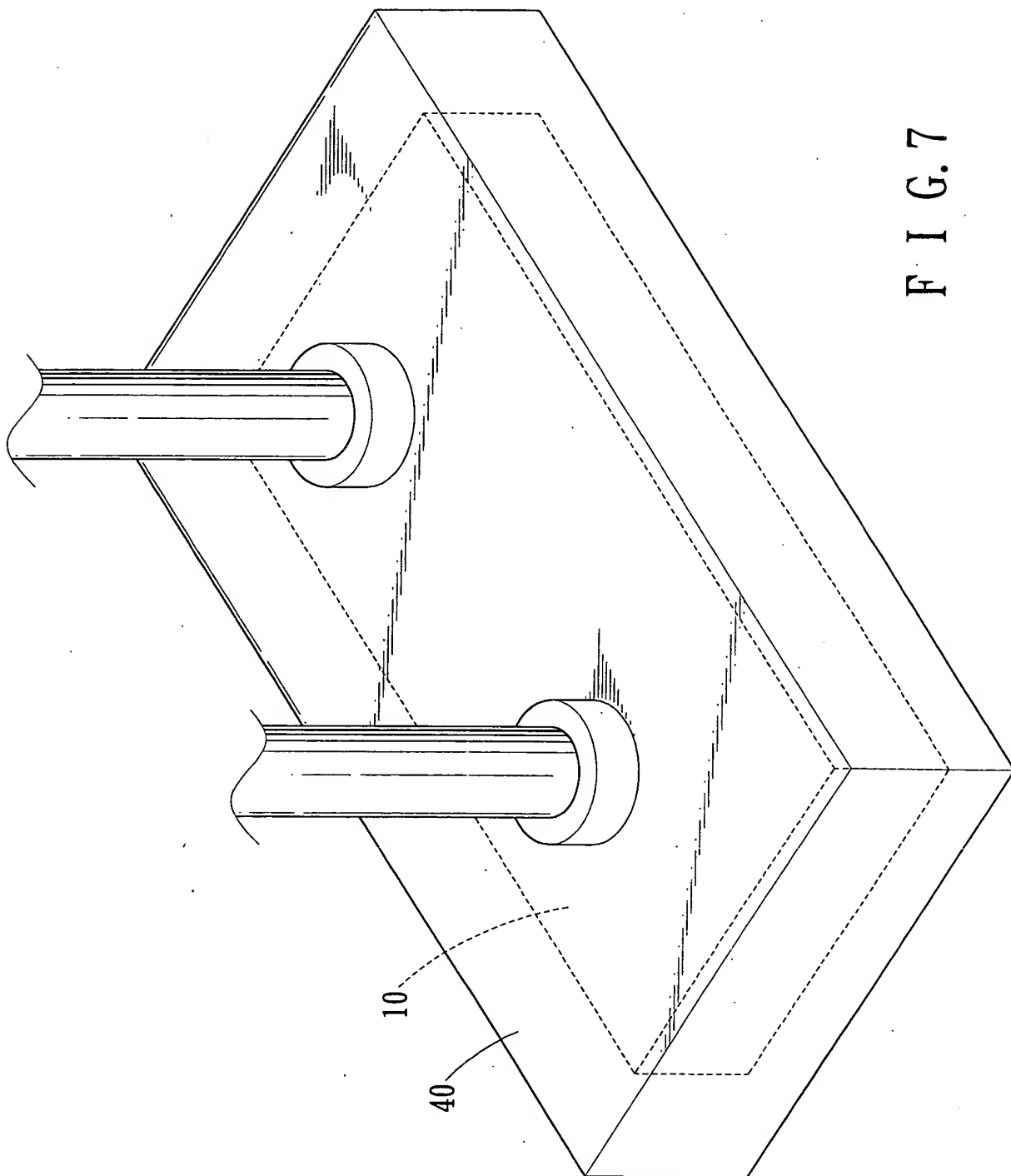


FIG. 7

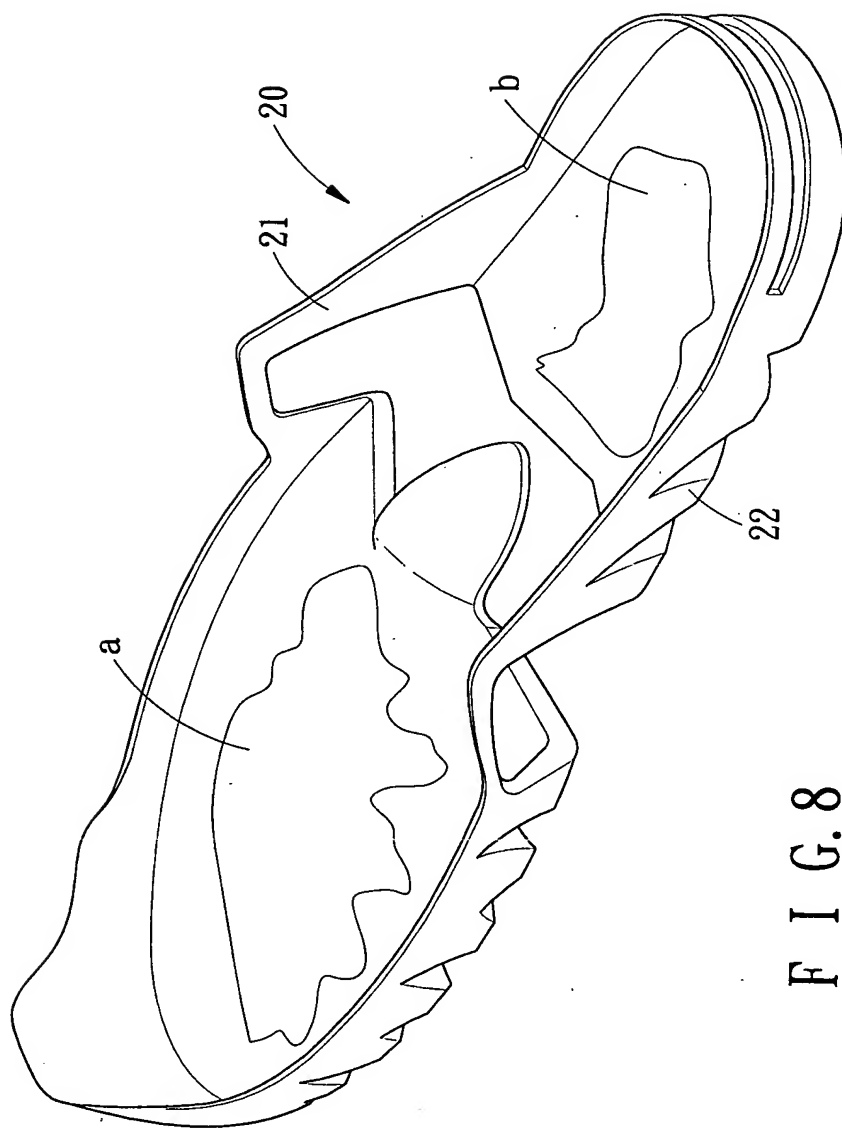


FIG. 8